

Date: Friday, 13/02/2009 1:02:43 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HINGE BRACKET
<b>Job Number</b> : 45799	
<b>Estimate Number</b> : 10349	
<b>P.O. Number</b> :	<b>Part Number</b> : D28582
<b>This Issue</b> : 13/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2858 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 41439	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/02/2009 <b>Qty:</b> 24 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.02.13</u>	
<b>Comment</b> : Est C 00.06.22 Removed P/O for powder coat EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01250	6061-T6 Bar 1.50 x 1.25
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**Comment:** Qty.: 0.1767 f(s)/Unit Total : 4.2412 f(s)

Material: 1.50" X 1.25"

6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)

(M6061T6B15001250

Batch M10746

Scrap = 8"

JP 09/02/18

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blanks 6.02"

Note: 1 Blank Makes 3 Parts

JP 09/02/18 (8)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2858-2

2-Deburr

(21)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

JP 09/02/20

(21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 13/02/2009 1:02:43 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 45799

Part Number: D28582

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 09/02/23 (21)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

FD 09/02/23 (21)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

M109996

START TIME: 10:20AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 10:50AM

9/09-02-24 (21)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BF 09-02-24 (21)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Pc 9/4/20 (21)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/25 (21)

Job Completion



h 09.02.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 45799
Description: Hinge Bracket		Part Number: D2858-2
Inspection Dwg: D2858	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

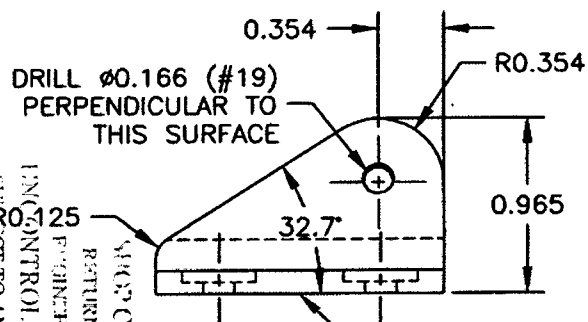
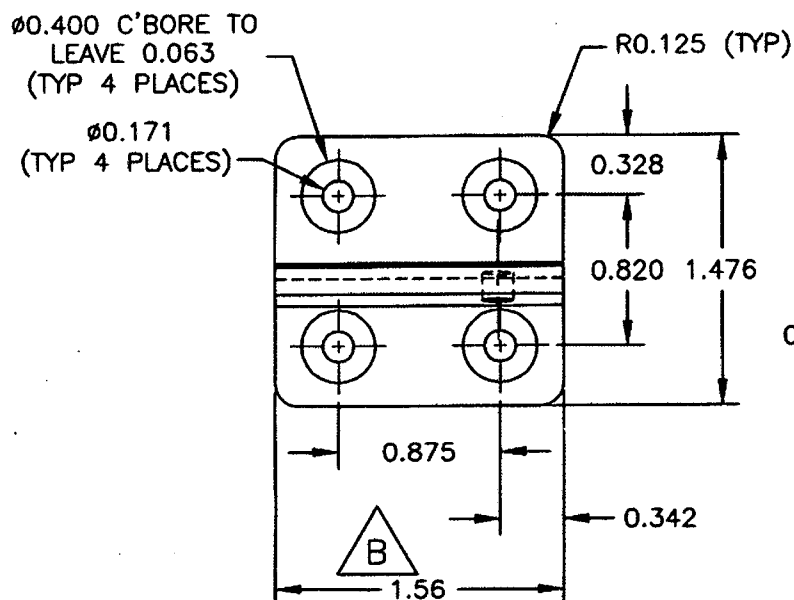
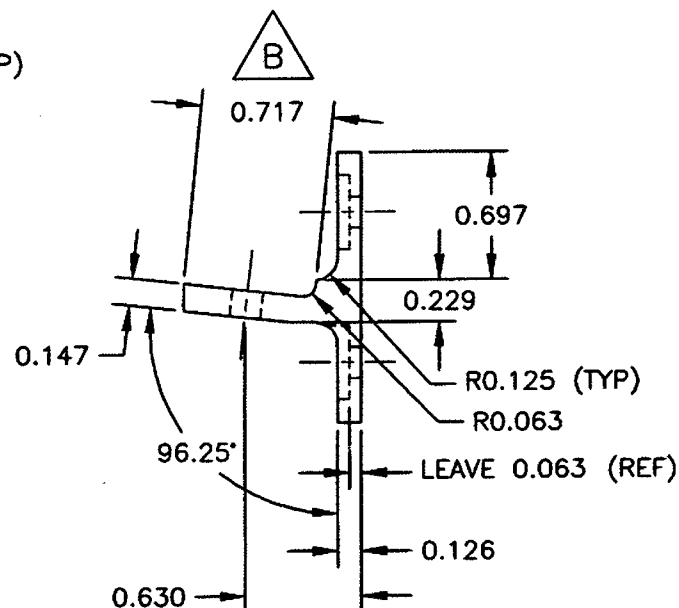
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	Ø .172				
Ø0.400	+0.005/-0.000	Ø .401				
R0.125	+/-0.010	R .125				
0.328	+/-0.010	.327				
0.820	+/-0.005	.820				
1.476	+/-0.010	1.472				
0.342	+/-0.010	.340				
0.875	+/-0.010	.874				
1.56	+/-0.030	1.56				
0.147	+/-0.010	.141				
0.717	+/-0.010	.717				
0.697	+/-0.010	.697				
0.229	+/-0.010	.229				
R0.125	+/-0.010	R .125				
R0.063	+/-0.010	R .063				
0.063	+/-0.010	.063				
0.126	+/-0.010	.126				
0.630	+/-0.010	.630				
R0.354	+/-0.010	R .354				
0.965	+/-0.010	.969				
Ø0.166	+0.005/-0.000	Ø .166				

Measured by: mms	Audited by: J.F.	Prototype Approval:	N/A
Date: 09/02/20	Date: 09/02/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	

**DART****RELEASED**  
99.01.09 KE

DESIGN	DATE	CHECKED	APPROVED	DRAWN BY	DRAWING NO.	REV. B
1E	99.02.28	UP	KE	1E	D2858	SHEET 1 OF 1
HINGE BRACKET					DATE	SCALE
A					98.12.14	1:1
B					99.02.28	
NEW ISSUE					0.717 WAS 0.667, 1.56 WAS 1.559	

ENGRAVE P/N CENTERED ON  
BASE 0.003 DEEP (0.010 MAX)**D2858-1 SHOWN**  
**D2858-2 OPPOSITE**

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED